

Date: Thursday, 6/21/2007 2:28:46 PM
 User: Kim Johnston

Process Sheet

| | | | |
|-----------------------|--|------------------|------------------------------|
| Customer | : CU-DAR001 Dart Helicopters Services | Drawing Name | : SPACER BUSHING |
| Job Number | : 33046 | | |
| Estimate Number | : 10826 | | |
| P.O. Number | : N/A | Part Number | : D23273 |
| This Issue | : 6/21/2007 S.O. No. : N/A | Drawing Number | : D2327 REV D |
| Prsht Rev. | : NC | Project Number | : N/A |
| First Issue | : N/A Type : MACHINED PARTS | Drawing Revision | : D |
| Previous Run | : 31785 | Material | : N/A |
| Written By | : | Due Date | : 7/20/2007 Qty: 50 Um: Each |
| Checked & Approved By | : <u>JA 07.06.22</u> | | |
| Comment | : Est. F 05.11.02 Removed 303 SS KJ/EC | | |

Additional Product

Job Number:



| | | |
|---------|-----------------------|---------------|
| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|

| | | |
|-----|-----------|------------------|
| 1.0 | M304R0375 | 304 SS ROUND BAR |
|-----|-----------|------------------|



Comment: Qty.: 0.1641 f(s)/Unit Total : 8.2058 f(s)

Inventory

Material: AISI 304 Round Bar Ø0.375"

(M304R0.375)

Batch: M102301

DIP 07/08/28

| | | |
|-----|----------|--------------------------|
| 2.0 | HARDINGE | HARDINGE CNC LATHE SMALL |
|-----|----------|--------------------------|



Comment: HARDINGE CNC LATHE SMALL

Turn per Folio FA232 and Dwg D2327

Deburr

DIP 07/08/28

| | | |
|-----|-----|--|
| 3.0 | QC2 | INSPECT PARTS AS THEY COME OFF MACHINE |
|-----|-----|--|



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

DIP 07/08/28

| | | |
|-----|-----|--------------|
| 4.0 | QC8 | SECOND CHECK |
|-----|-----|--------------|



Comment: SECOND CHECK

86 07-08-28

50

| | | |
|-----|-------------|-----------------------|
| 5.0 | PACKAGING 1 | PACKAGING RESOURCE #1 |
|-----|-------------|-----------------------|



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

CP 07/08/29 (50)

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: D Date: 07/08/29
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Thursday, 6/21/2007 2:28:46 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SPACER BUSHING

Job Number: 33046

Part Number: D23273

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



(59)

Comment: FINAL INSPECTION/W/O RELEASE

D 07108/29

Job Completion



U 07-08-28

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

| | | | |
|--|--|---------------------|---------|
| DART AEROSPACE LTD | | Work Order: | 33046 |
| Description: Spacer Bushing | | Part Number: | D2327-3 |
| Inspection Dwg: D2327 Rev: D | | Page 1 of 1 | |

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

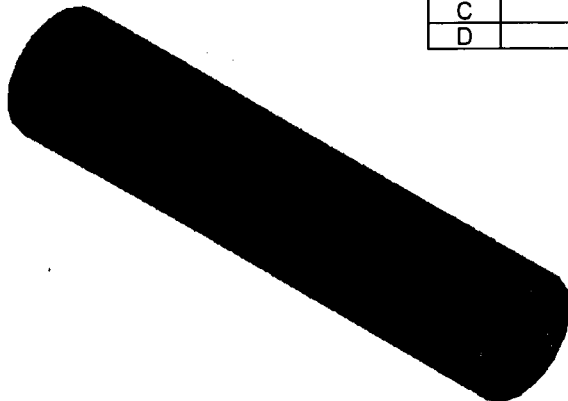
| Drawing Dimension | Tolerance | Actual Dimension | Accept | Reject | Method of Inspection | Comments |
|-------------------|---------------|------------------|--------|--------|----------------------|----------|
| Ø0.375 | +0.005/-0.000 | 0.3755 | ✓ | | | |
| Ø0.257 | +0.005/-0.000 | 0.261 | ✓ | | | |
| 1.750 | +/-0.010 | 1.752 | ✓ | | | |
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| Measured by: | DSP | Audited by: | EC | Prototype Approval: | N/A |
| Date: | 07/08/28 | Date: | 07.08.28 | Date: | N/A |

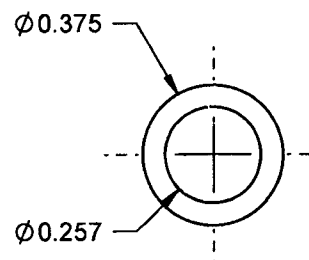
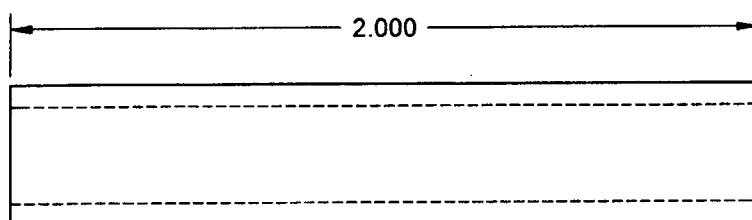
| Rev | Date | Change | Revised by | Approved |
|-----|----------|----------------------|------------|----------|
| A | 04.01.13 | New Issue | KJ/RF | |
| B | 06.11.24 | Dwg Revision revised | KJ/JLM | EA |



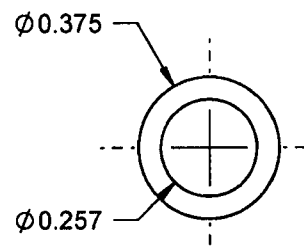
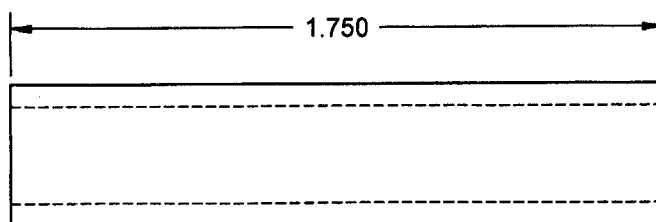
| | | | |
|------------------|----------------|---|------------------------|
| DESIGN BW | DRAWN BY CB | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED LE | APPROVED CH | DRAWING NO. D2327 | REV. D SHEET 1 OF 1 |
| DATE 06.10.12 | | TITLE SPACER BUSHING | SCALE 2:1 |
| REV | DATE | DESCRIPTION | |
| A | 94.12.17 | NEW ISSUE | |
| B | 95.12.06 | LENGTH CHANGE | |
| C | 03.05.13 | 303 SS SPEC ADDED | |
| D | 06.10.12 | REMOVE 303 SS MATERIAL | |



RELEASED
06.11.14



D2327-1 SPACER BUSHING



D2327-3 SPACER BUSHING

NOTES:

- 1) MATERIAL: AISI 304/316 SS, Ø0.375, 0.065 WALL SEAMLESS ROUND TUBING (REF. DART SPEC M304TR0.375W.065)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED
- 5) BREAK ALL SHARP CORNERS TO 0.010 MAX

SHOP COPY
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SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 33046

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